

Stock Feeder

(Model 36-850)



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TABLE OF CONTENTS

SAFETY RULES FOR ALL TOOLS	3
ADDITIONAL SAFETY RULES FOR STOCK FEEDERS	4
UNPACKING	4
ASSEMBLY	
Assembling Table Mounting Bracket	4
Assembling Feeder	4
CONNECTING STOCK FEEDER TO POWER SOURCE	
Power Connections	5
Grounding Instructions	5
FEED RATE ADJUSTMENTS	6
MOTOR CONTROL/SPEED SWITCH	6
OPERATING CONTROLS	7
FEED ROLLER REPLACEMENT	7
LUBRICATION	7
USING THE FEEDER ON A TABLE SAW	8
USING THE FEEDER ON A JOINTER	8
USING THE FEEDER ON A SHAPER	8
PARTS, SERVICE OR WARRANTY ASSISTANCE	9
AUTHORIZED SERVICE STATIONS	10-11
WARRANTY	12

SAFETY RULES

Woodworking can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, push sticks, hold-downs, featherboards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don't try it. Figure out an alternative procedure that feels safer. REMEMBER: Your personal safety is your responsibility.

This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine not be modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, DO NOT use the machine until you have first contacted Delta to determine if it can or should be performed on the product.

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WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL.** Learn the tool's application and limitations as well as the specific hazards peculiar to it.
2. **KEEP GUARDS IN PLACE** and in working order.
3. **ALWAYS WEAR EYE PROTECTION.**
4. **GROUND ALL TOOLS.** If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter lug must be attached to a known ground. Never remove the third prong.
5. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it "on."
6. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
7. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.
8. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
9. **MAKE WORKSHOP CHILDPROOF** - with padlocks, master switches, or by removing starter keys.
10. **DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.
11. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
12. **WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
13. **ALWAYS USE SAFETY GLASSES.** Wear safety glasses (must comply with ANSI Z87.1). Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use face or dust mask if cutting operation is dusty.
14. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
15. **DON'T OVERREACH.** Keep proper footing and balance at all times.
16. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
17. **DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters, etc.
18. **USE RECOMMENDED ACCESSORIES.** The use of accessories and attachments not recommended by Delta may cause hazards or risk of injury to persons.
19. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in "OFF" position before plugging in power cord.
20. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
21. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
22. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
23. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
24. **DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drugs, alcohol or any medication.
25. **MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.
26. **WARNING:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR STOCK FEEDERS

1. **ALWAYS** use machine guards, as appropriate.
2. Cutting tools **MUST** be rotating before feeding.
3. **DO NOT** overload the cutting tool by feeding too fast.
4. **ALWAYS KEEP** hands away from rotating parts of feeder and cutting tool.
5. **PROVIDE** support for long stock on outfeed end of table.
6. **STOP** the feeder before stopping the cutting tool.
7. **DISCONNECT** from power source before making repairs or adjustments.

UNPACKING

Carefully unpack the stock feeder and all loose items from the shipping carton.

ASSEMBLY

ASSEMBLING TABLE MOUNTING BRACKET

Decide the location you wish to position the mounting bracket of the feeder assembly. Refer to illustrations shown in Figs. 12, 13 and 14 for assistance when mounting the feeder assembly to a table saw, jointer or shaper. To mount the feeder assembly, proceed as follows:

1. Position the mounting bracket (A) Fig. 2, at the desired location on the machine.
2. Mark the locations where four mounting holes must be drilled in the table.
3. Center punch and drill four 3/8" diameter thru holes at the locations marked in STEP 2. **NOTE:** Be certain **NOT** to drill through any table ribs or table supports.
4. Fasten mounting bracket (A) Fig. 2, to the table with 4 two inch-long bolts, three of which are shown at (B) Fig. 2, 8 flat washers, 4 lockwashers and 4 hex nuts supplied.

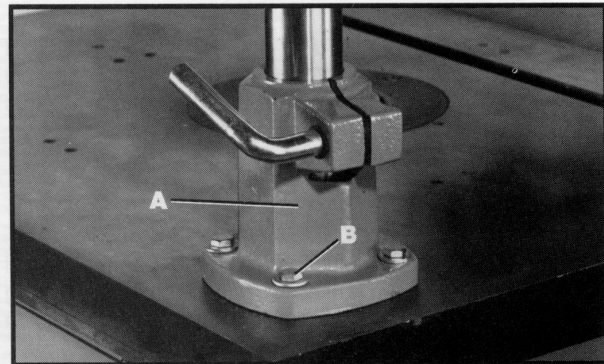


Fig. 2

ASSEMBLING STOCK FEEDER

1. Loosen locking lever (C) Fig. 3, and insert vertical arm (D) of support assembly into mounting bracket (A).
2. Tighten locking lever (C) Fig. 3, to hold feeder assembly in position on the table.
3. Insert two 3-1/2 inch-long screws supplied, through two handles (E) Fig. 3, and thread jam nuts onto ends of screws.
4. Position two handles (E) Fig. 3, over the threaded holes in two handwheels (F) and thread handles into handwheels.
5. Loosen screw (G) Fig. 3, and position end bracket (H) over end of horizontal support arm (J); tighten screw (G).
6. Assemble angle bracket (L) Fig. 3, onto feeder (M) and tighten locking lever (N).
7. Assemble feeder (M) Fig. 3, with angle bracket (L) onto end bracket (H). Tighten locking lever (P). **NOTE:** Adjustments to feeder mounting positions can be made later.

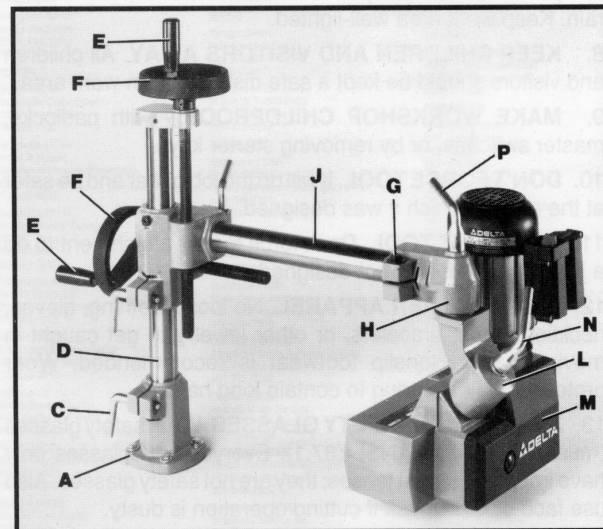


Fig. 3

CONNECTING STOCK FEEDER TO POWER SOURCE

POWER CONNECTIONS

A separate electrical circuit should be used for your tools. This circuit should not be less than #12 wire and should be protected with a 20 Amp time lag fuse. If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and 3-pole receptacles which accept the tool's plug. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool. All line connections should make good contact. Running on low voltage will damage the motor.

GROUNDING INSTRUCTIONS

CAUTION: THIS TOOL MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-hole receptacles that accept the tool's plug, as shown in Fig. 4.

Repair or replace damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet and a plug that looks like the one shown in Fig. 4. A temporary adapter, which looks like the adapter illustrated in Fig. 5, may be used to connect this plug to a 2-pole receptacle, as shown in Fig. 5, if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. **THIS ADAPTER IS NOT APPLICABLE IN CANADA.** The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground, such as a properly grounded outlet box, as shown in Fig. 5.

CAUTION: IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE HAVE A CERTIFIED ELECTRICIAN CHECK THE RECEPTACLE.

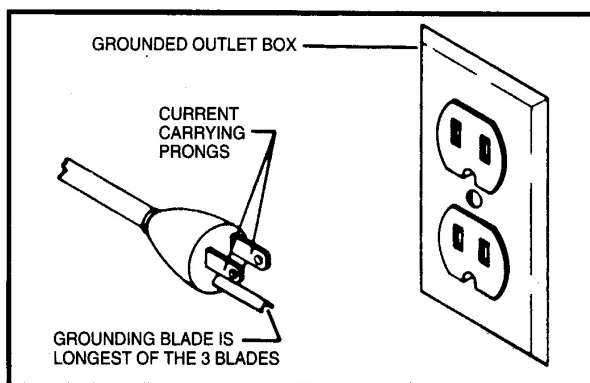


Fig. 4

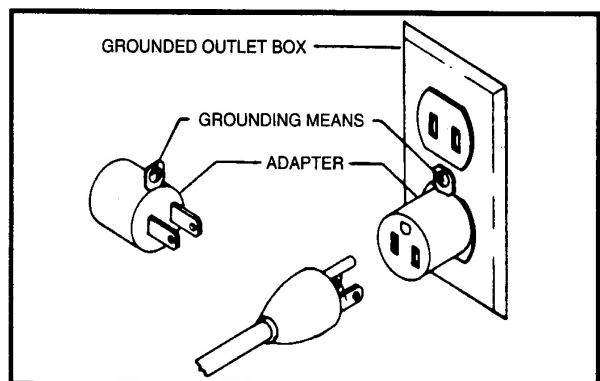


Fig. 5

FEED RATE ADJUSTMENTS

Feed rates of 14, 26, 33 and 63 feet per minute or 4, 8, 10 and 19 meters per minute are available with the stock feeder. A gear arrangement and feed rate chart shown in Fig. 7, is attached to the inside cover of the gear box.

To remove gear box cover (A) Fig. 6, turn knob (B) counterclockwise. The numbers shown within the circles in Fig. 7, refer to the number of teeth on the gears as shown at (C), (D), (E) and (F). With the 34 and 16 teeth gears in the arrangement shown at (C), the feed rate will be 14 FT/MIN (4 M/MIN). By interchanging the 34 and 16 teeth gears as shown at (D) Fig. 7, the feed rate will become 63 FT/MIN (19 M/MIN).

The additional set of gears with 26 and 24 teeth, supplied with the feeder, will provide 26 and 33 FT/MIN (8 and 10 M/MIN), depending on the gear arrangement as shown at (E) and (F) Fig. 7.

To interchange gears (G) and (H) Fig. 8, or to remove gears and replace them with gears (K) and (L), loosen and remove hex nuts (M) on gear shaft and remove gears.

NOTE: Always remove bottom gear first when interchanging or replacing gears.

Reassemble gears as desired on gear shafts and replace hex nuts (M) Fig. 8.

MOTOR CONTROL SPEED SWITCH

To operate the feeder in a forward position, turn switch (A) Fig. 9, clockwise. To operate the feeder in the opposite direction, turn switch (A) counterclockwise.

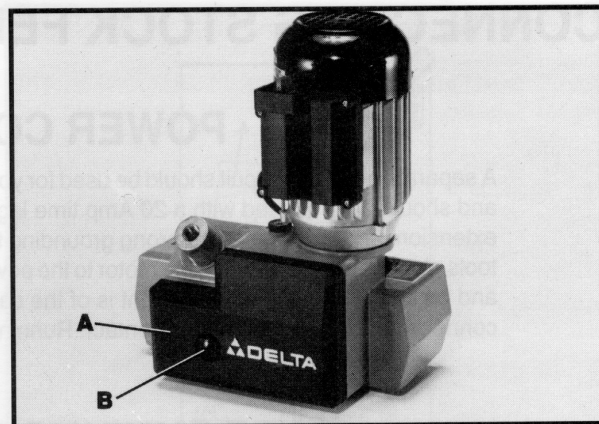


Fig. 6

4-SPEED 3-ROLLER STOCK FEEDER			
	GEAR ARRANGEMENT	FEED RATE	
		FT/MIN	M/MIN
C		14	4
D		63	19
E		26	8
F		33	10

Fig. 7

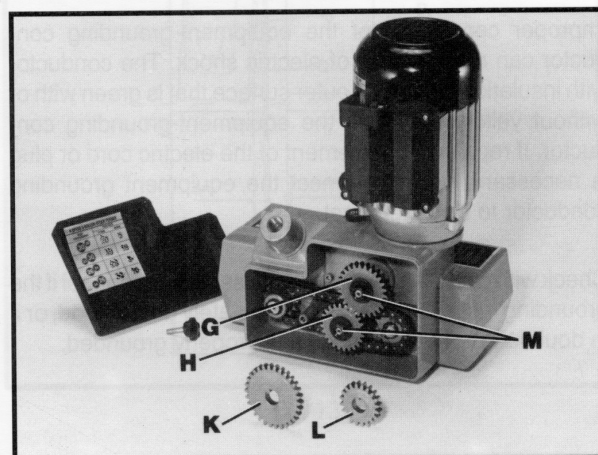


Fig. 8

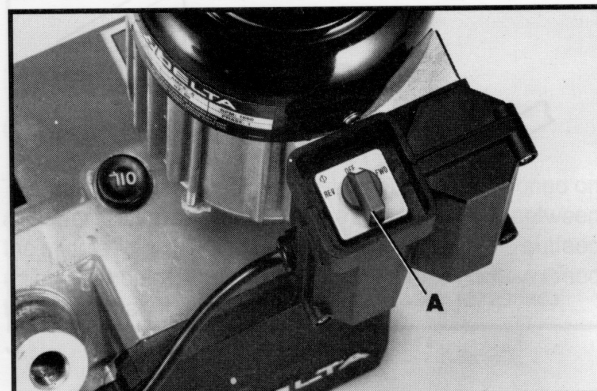


Fig. 9

OPERATING CONTROLS

MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

1. The entire feeder assembly (A) Fig. 10, can be rotated 360 degrees in the mounting bracket (B) by loosening locking lever (C).
2. To raise or lower the feeder assembly (A) Fig. 10, loosen locking lever (D) and rotate handwheel (E).
3. To move the feeder assembly (A) Fig. 10, inward or outward, loosen locking lever (G) and rotate handwheel (H).
4. To adjust the position of feeder (F) Fig. 10, loosen locking levers (K) and/or (L).
5. Tighten all locking levers after adjustments are completed.

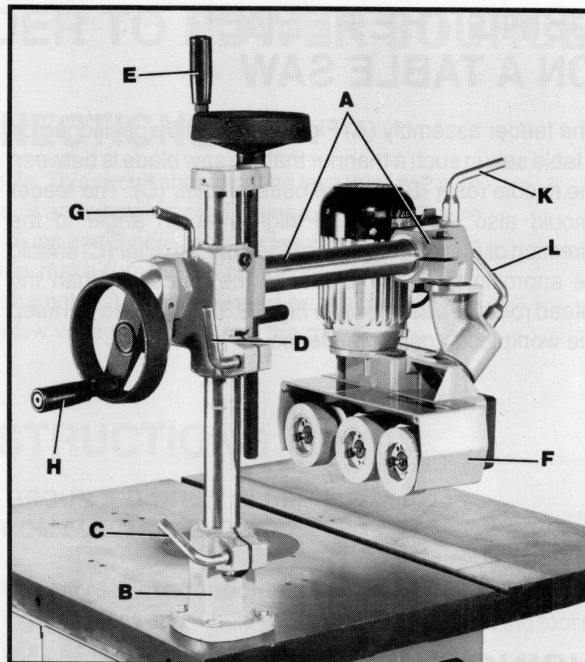


Fig. 10

FEED ROLLER REPLACEMENT

MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

Each feed roller (A) Fig. 11, is removable for repair or replacement by removing two screws (B) and removing the feed roller. Replace screws (B) Fig. 11, after feed roller is replaced.

LUBRICATION

MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

The feed rollers (A) Fig. 11, should be lubricated approximately every 200 hours of use with grease (Delta Part No. 999-02-023-1213) through grease fittings (C) using grease gun supplied with the machine.

The gear chains should be coated periodically with light machine oil.

The gear oil should be changed approximately every 1000 hours of service or after heavy extended use with #90 weight gear oil (Delta Part No. 999-01-013-1210). To gain access to the gear oil chamber, turn oil cap (D) counter-clockwise. The oil level should be kept 2 to 2-1/4" below top of gear case.

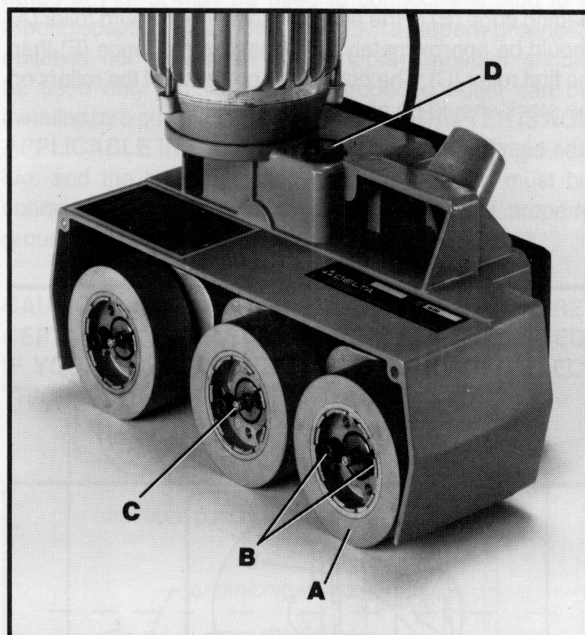


Fig. 11

USING THE FEEDER ON A TABLE SAW

The feeder assembly (A) Fig. 12, should be positioned on a table saw in such a manner that the saw blade is between the middle roller (B) and the outfeed roller (C). The feeder should also be positioned slightly at an angle to the direction of feed. For example, the outfeed roller (C) should be approximately 1/4" closer to the fence (D) than the infeed roller (E), as shown in Fig. 12. This position will keep the workpiece against the fence.

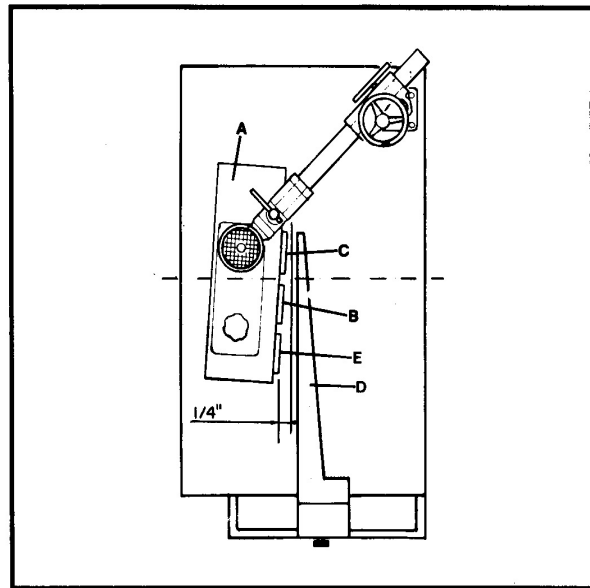


Fig. 12

USING THE FEEDER ON A JOINTER

The feeder assembly (G) should be positioned on a jointer in such a manner that all the rollers (A), (B) and (C) are over the outfeed table (D) of the jointer, as shown in Fig. 13. The first roller (C) should be approximately 1/4" from the leading edge (E) of the outfeed table and the third roller (A) should be approximately 1/4" closer to the fence (F) than the first roller (C). The downward pressure of the rollers on the stock should be as light as possible.

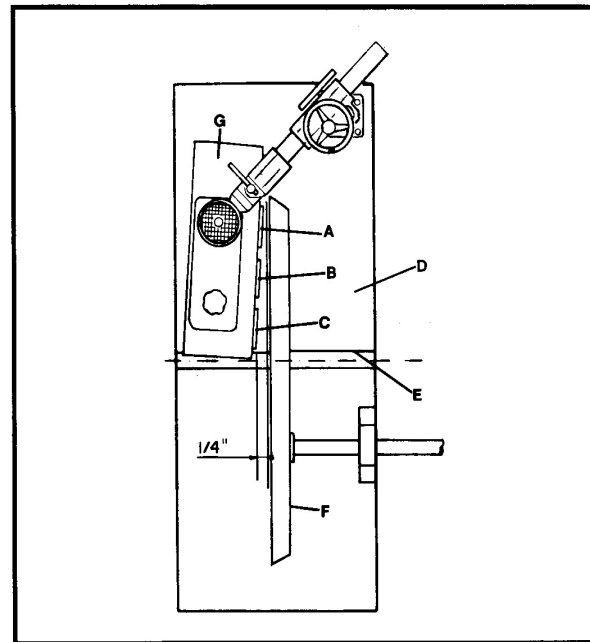


Fig. 13

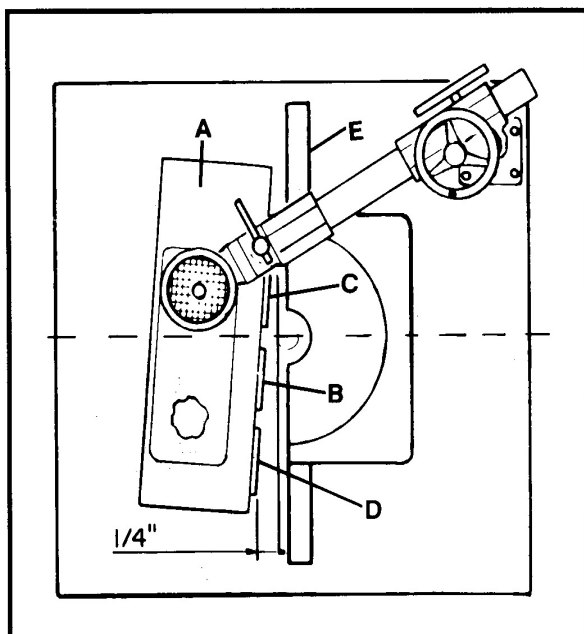


Fig. 14

USING THE FEEDER ON A SHAPER

The feeder assembly (A) Fig. 14, should be positioned on a shaper in such a manner that the shaper cutter is between the middle roller (B) and the outfeed roller (C). The outfeed roller (C) should be approximately 1/4" closer to the outfeed fence (E) than the infeed roller (D).

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Delta Machinery

Delta will repair or replace, at its expense and at its option, any Delta machine, machine part, or machine accessory which in normal use has proven to be defective in workmanship or material, provided that the customer notifies his supplying distributor of the alleged defect within two years from the date of delivery to him, of the product and provides Delta Machinery with reasonable opportunity to verify the defect by inspection. Delta Machinery may require that electric motors be returned prepaid to the supplying distributor or authorized service center for inspection and repair or replacement. Delta Machinery will not be responsible for any asserted defect which has resulted from misuse, abuse or repair or alteration made or specifically authorized by anyone other than an authorized Delta service facility or representative. Under no circumstances will Delta Machinery be liable for incidental or consequential damages resulting from defective products. This warranty is Delta Machinery's sole warranty and sets forth the customer's exclusive remedy, with respect to defective products; all other warranties, express or implied, whether of merchantability, fitness for purpose, or otherwise, are expressly disclaimed by Delta.

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